

ABSTRACT

A method of securing a sealing washer to one surface of a metal sheet while welding a head of a fastener to a second surface of a metal sheet, the method comprising: compressing the head onto the second surface of the sheet between a first electrode engaging the head and a second electrode engaging the first surface of the sheet, welding the head to the second surface of the sheet by electrical resistance welding to heat the first surface of the sheet proximate to the first electrode, urging a sealing washer into the heated first surface with the second electrode to heat the sealing washer and thereby bond the sealing washer to the first surface.